



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.1513

Job Sheet 205050



Part No: 647.1513

Job Qty: 12 pcs

Part Name: Upper Deflector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/27/19

Job Tracking No:

Due Date: 2/21/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: 647.1500 REV.E IPP Rev.A New issue JFS 16/03/09 Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Bandsaw - 1	12 pcs	2/21/20	2/21/20	0.00	0.03	Bandsaw - 1	DAS 52 9-89	2/03/02
110	HAAS 4 Axis - B4B	12 pcs	2/21/20	2/21/20	0.50	11.43	HAAS - 1 - B4B	52 9-89	2/03/02
							HAAS - 2 - B4B		
							HAAS - 3 - B4B		
							HAAS - 4 - B4B		
120	QC 2	12 pcs	2/21/20	2/21/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51	DAS 52 9-89	2/03/02
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		



DART Aerospace Ltd.
1270 Aberdeen Street
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CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S259982



Part: 647.1513

Job No: 205050

Serial No/Batch: S259982

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 03/02/20

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130	QC 8	12 pcs	2/21/20	0.00 0.00	QC 2 - 63	
					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
					QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
140	Outsource - 4 - Anodize	12 pcs	2/21/20		QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					QC 8 - 61	
					ATG001-VC	5
					2020-03-05	
150	Packaging 2-1 - Receive - B4B	12 pcs	2/21/20	0.00 0.00	Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 -	
					MAR 16 2020	

					B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
155	QC 6	12 pcs	2/21/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	81
					QC 6 - 81	9-89
180	Packaging 3-1 - Stock - B4B	12 ✓ pcs	2/21/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS
					Packaging 3 - 4 - B4B	CC 5015 80
					Packaging 3 - 5 - B4B	9-89
					Packaging 3 - 6 - B4B	APR 16 2020
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	

					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	
					QC 21 - SA - 21	✓
					QC 21 - SA - 70	
					QC 21 - SA - 53	
190 QC 21 - SA	12 ✓ pcs	2/21/20	0.00	0.00		

CCK015

DAS
21
9-08

APR 16 2020

Part Op 100 - (Bandsaw) Cut Blank at 19.500" (1 blank makes 2 parts)

Descriptions: 110 - (HAAS CNC Vertical Machine) 1-Machine per folio FB465

120 - (QC2- Inspect parts off machine FAI/FAIB)

130 - (QC8- Inspect parts - second check)

140 - Issue P/O to ATG : H6026 Hard Anodize Color Black / Prime as per Dwg 647.1500

150 - (Receive & Inspect for Damage & Mat'l Certs)

155 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

190 - (QC21- Final Inspection - Work Order Release)

Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M7075T6S0.375X6.000	7075-T6S Sheet .375" Thick Plate X 6" Wide	9.7560 ft (.813 ea)	100-Bandsaw - 1	S 255554 S229793 → SCRAP 0.45'	

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Bandsaw - 1	M7075T6S0.375X6.000	10	18	0

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Upper Deflector	0.130inches ± 0.010	0.140 0.120	0.130	
2	Upper Deflector	45.000degrees ± 0.500	45.500 44.500	Angle 45°	
3	Upper Deflector	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter 0.177	
4	Upper Deflector	0.318inches ± 0.005	0.323 0.313	0.318	
5	Upper Deflector	23.000degrees ± 0.500	23.500 22.500	Angle 23°	
6	Upper Deflector	4.220inches ± 0.002	4.222 4.218	4.220	
7	Upper Deflector	2.110inches ± 0.002	2.112 2.108	2.110	
8	Upper Deflector	10.180inches ± 0.010	10.190 10.170	10.180	
9	Upper Deflector	0.188inches + 0.005 - 0.001	0.193 0.187	Diameter 0.187	
10	Upper Deflector	4.000inches ± 0.010	4.010 3.990	4.000	
11	Upper Deflector	0.700inches ± 0.010	0.710 0.690	0.700	
12	Upper Deflector	0.310inches ± 0.010	0.320 0.300	0.31	
13	Upper Deflector	60.000degrees ± 0.500	60.500 59.500	Angle 60°	
14	Upper Deflector	10.890inches ± 0.010	10.900 10.880	10.890	
15	Upper Deflector	6.340inches ± 0.010	6.350 6.330	6.339	
16	Upper Deflector	0.921inches ± 0.005	0.926 0.916	0.921	
17	Upper Deflector	0.340inches + 0.000 - 0.002	0.340 0.338	0.339	
18	Upper Deflector	0.040inches ± 0.010	0.050 0.030	0.04	
19	Upper Deflector	45.000degrees ± 0.500	45.500 44.500	Angle 45°	
20	Upper Deflector	0.380inches ± 0.010	0.390 0.370	0.375	
21	Upper Deflector	10.950inches ± 0.010	10.960 10.940	10.950	

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046026



Supplier: ATG001-VC
A.T.G. Industries Inc
760 INDUSTRIELLE STREET
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046026

PO Date: 3/5/20

Due Date: 3/20/20

Purchase Order

Revision:

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-03-11

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	205058	647.1714	647.1700 Rev A	Plate : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Anodize and Prime as Per Dwg 647.1700 Rev. E	Firmed	-	3/18/20	49 pcs	0 pcs	49 pcs	\$31.15/pcs	\$1,526.35
2	205059	647.1715	647.1700 Rev E	Plate : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.1700 Rev. E	Firmed	-	3/18/20	30 pcs	0 pcs	30 pcs	\$31.15/pcs	\$934.50

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PURCHASE ORDER

POHB046026



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	205046	646.9811	646.9800 Rev A	Upper Deflector : Various STC's (Outsource process- Anodize per QSI017 4.1.10.1) Issue P/O to ATG : HARD ANODIZE COLOR BLACK, PRIME AS PER DWG 646.9800 REV. A	Firmed XB	-	3/20/20	8 pcs	0 pcs	8 pcs	\$33.50/pcs	\$268.00
											MAR 16 2020	
4	204004	C45-9-1	C45-9-1 Rev 6	Clock Spring Cover -Issue P/O -ANODIZE COLOR BLACK, PER IAW MIL-A-8625F TYPE 2 CLASS 2, Water sealant -Material type 6061T6 -Certificate of Conformity is required	Firmed XJC	-	3/20/20	20 pcs	0 pcs	20 pcs	\$5.59/pcs	\$111.80
											MAR 11 2020	
5	205071	647.7612	647.7600 Rev N/C	Breakaway Tip : Various STC's Issue P/O to ATG : Hard Anodize, Color Black and Prime as Per Dwg 647.7600	Firmed X8	-	3/20/20	8 pcs	0 pcs	8 pcs	\$11.60/pcs	\$92.80
											MAR 16 2020	

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PURCHASE ORDER

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Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
6	207545	654.3910	654.3900 Rev N/C	Handle -Issue P/O; -ANODIZE COLOR RED, PER IAW MPP- 172 Section 2.2 -Material type; 6061T6 -Certificate of Conformity is required	Firmed <i>X7</i>	-	3/11/20	7 pcs	0 pcs	7 pcs	\$5.59/pcs	\$39.13
7	205050	647.1513	647.1500 Rev E	Upper Deflector Issue P/O to ATG : Hard Anodize Color Black / Prime as per Dwg 647.1500	Firmed <i>X12</i>	-	3/20/20	12 pcs	0 pcs	12 pcs	\$12.95/pcs	\$155.40
8	200924	8NR-43	8NR-43 Rev 6	Side Plate-Mrk (Outsource process- Anodize per QSI017 4.1.10.1) -Issue P/O -ANODIZE COLOR BLUE, PER IAW MIL- A-8625F TYPE 2 CLASS 2, Water sealant -Material type 7075T6 -Certificate of Conformity is required	Firmed	-	3/20/20	5 pcs	0 pcs	5 pcs	\$5.59/pcs	\$27.95

Grand Total: \$3,155.93

Kimberley



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PURCHASE ORDER

POHB046026



Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

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A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Pack List

Number: 919824

Date: 16-Mar-20

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
8 ea	Part: 646.9811 Upper deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 128522 Job: 27063 PO: POHB046026		Rev: A Expiry Date: 05/29/2021 Line: 3
8 ea	Part: 647.7612 Breakaway Tip Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils). Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 128522 Job: 27065 PO: POHB046026		Rev: NC Expiry Date: 05/29/2021 Line: 5
12 ea	Part: 647.1513 Upper deflector Hard Black Anodize per MIL-A-8625F, Type III, Class2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Batch/Lot#: 128522 Job: 27067 PO: POHB046026		Rev: E Expiry Date: 05/29/2021 Line: 7

DAS
81
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MAR 16 2020

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DART AEROSPACE LTD.



A.T.G. Industries Inc.
760 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 919824

Date: 16-Mar-20

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Kimberley Guerin
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>MAR 16 2020</u> Certified Signature: <u></u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.		
Made in Canada.			